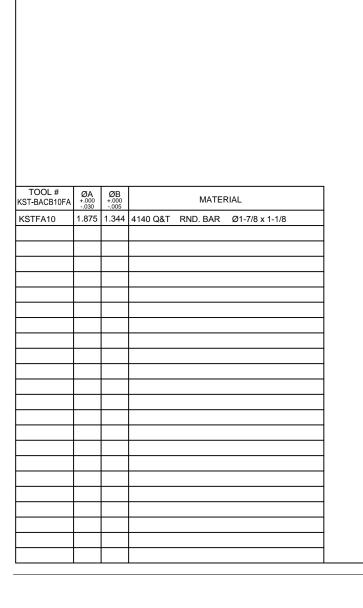


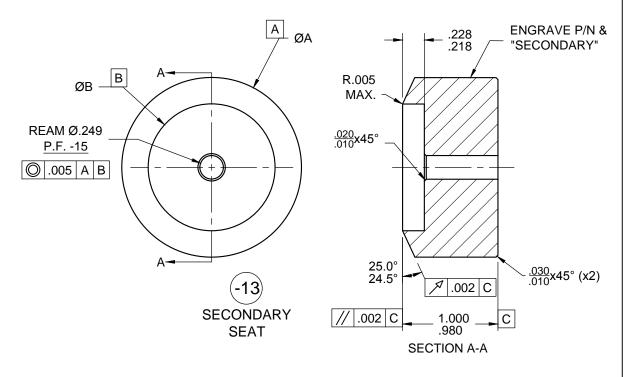
TOOL # KST-BACB10FA	ØA +.000 002	PIN TYPE	MATERIAL					
KSTFA10	.623	III	1018	RND. BAR	Ø5/8 x 5/8			

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

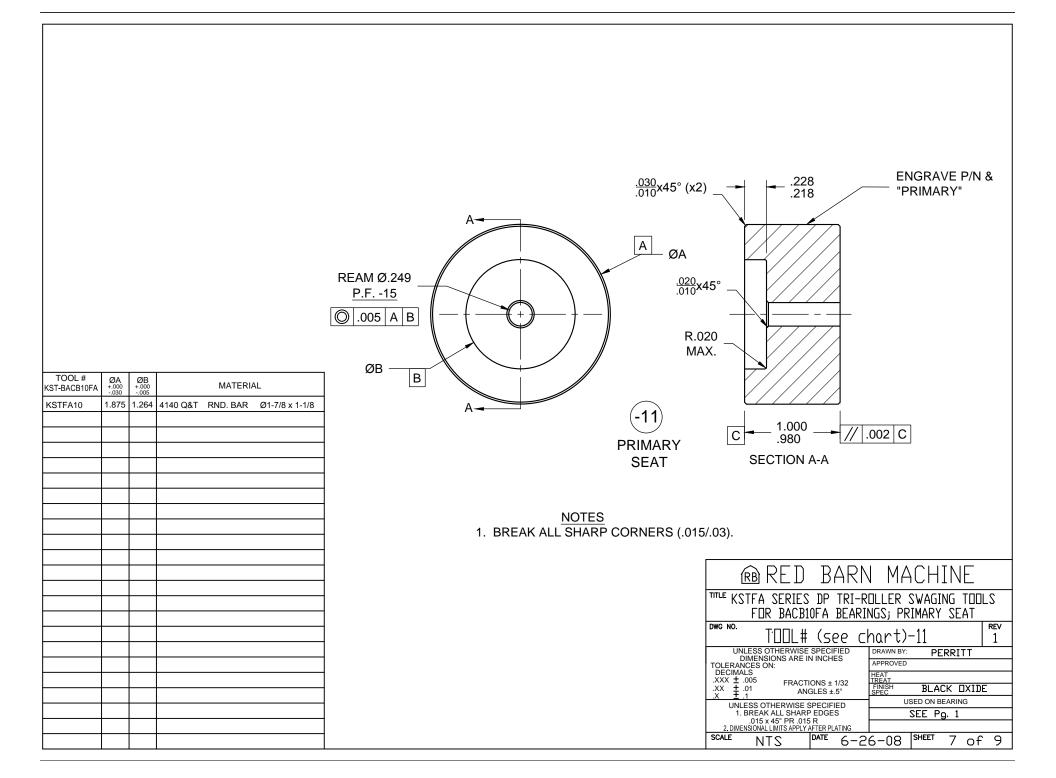
® RED ∃	BARN	I MA	CHI	.NE				
TULE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; LOCATING PIN								
DWG NO. T□□L# (S	ee ch	nart)-	-15		REV 1			
UNLESS OTHERWISE SPEC DIMENSIONS ARE IN INCI TOLERANCES ON: DECIMALS	DRAWN BY: APPROVED	PEF	RRITT					
.XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS:		HEAT TREAT FINISH SPEC		< DXIDE	:			
UNLESS OTHERWISE SPECI 1. BREAK ALL SHARP EDG .015 x 45° PR .015 R	SEE Pg. 1							
2. DIMENSIONAL LIMITS APPLY AFTER F		L 6-08	SHEET	9 of	<u> </u>			

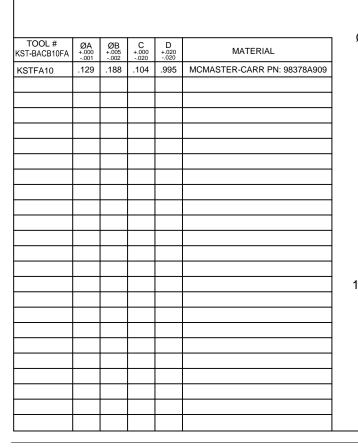


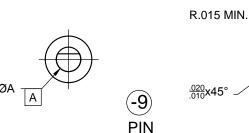


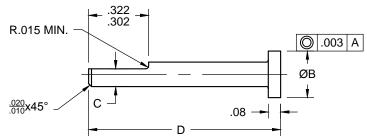
NOTES 1. BREAK ALL SHARP CORNERS (.015/.03).

® RED BARN MACHINE								
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; SECONDARY SEAT								
TOOL# (see chart)-13 REV 1								
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DERRANCES ON: DRAWN BY: PERRITT APPROVED								
DECIMALS .XXX ± .005 .XX ± .01 .XX ± .01 ANGLES ±.5° FRACTIONS ± 1/32 FINISH SPEC BLACK DXID	E							
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x45° PR. 015 R USED ON BEARING USED ON BEARING SEE Pg. 1								
2. DIMENSIONAL LIMITS APPLY AFTER PLATING SCALE NTS DATE 6-26-08 SHEET 8 o	f 9							



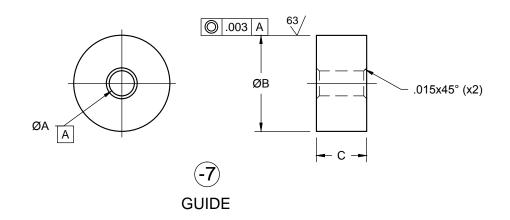






<u>NOTES</u>
1. BREAK ALL SHARP CORNERS (.015/.03).

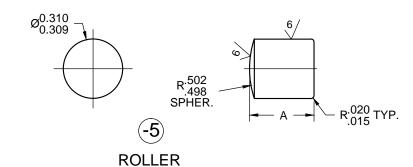
®RED BARN	
TILE KSTFA SERIES DP TRI-R FOR BACB10FA	OLLER SWAGING TOOLS BEARINGS; PIN
TDDL# (see	chart)-9 REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:	DRAWN BY: PERRITT APPROVED
DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	HEAT TREAT FINISH BLACK DXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES	USED ON BEARING SEE Pg. 1
.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
scale NTS Date 6-2	6-08 SHEET 6 of 9



TOOL # KST-BACB10FA	ØA +.001 001	ØB +.000 002	C +.000 010	MATERIA	MATERIAL				
KSTFA10	.131	.623	.346	BRONZE RND. BAR	Ø5/8 x 1/2				

<u>NOTES</u>
1. BREAK ALL SHARP CORNERS (.015/.03).

RB R	ED B	ARN	I MA	CH.	INE	
TITLE KSTFA S	SERIES DP FOR BACB					LS
DWG NO	T00L# (see (:hart))-7		REV 1
DIMENSIC TOLERANCES ON:	HERWISE SPEC INS ARE IN INCI	DRAWN BY: APPROVED	PE	RRITT		
DECIMALS .XXX ± .005 .XX ± .01 .X + .1	FRACTIONS :		HEAT TREAT FINISH SPEC			
	ERWISE SPECI		SED ON BE			
	LL SHARP EDG 5° PR .015 R	SEE Pg. 1				
	S PR .015 R MITS APPLY AFTER F	PLATING				
SCALE NT	S DATE	6-2	6-08	SHEET	5 of	9



TOOL #	A +.001 001		MATERIAL	
KST-BACB10FA				
KSTFA10	.335	.310 MINUS	GAUGE PIN	MSC#89031009

RB	RED	В	AR	Ν	MA	4CHII	NE
CTEA	CEDIEC	חח	TDI	חח		CLACING	

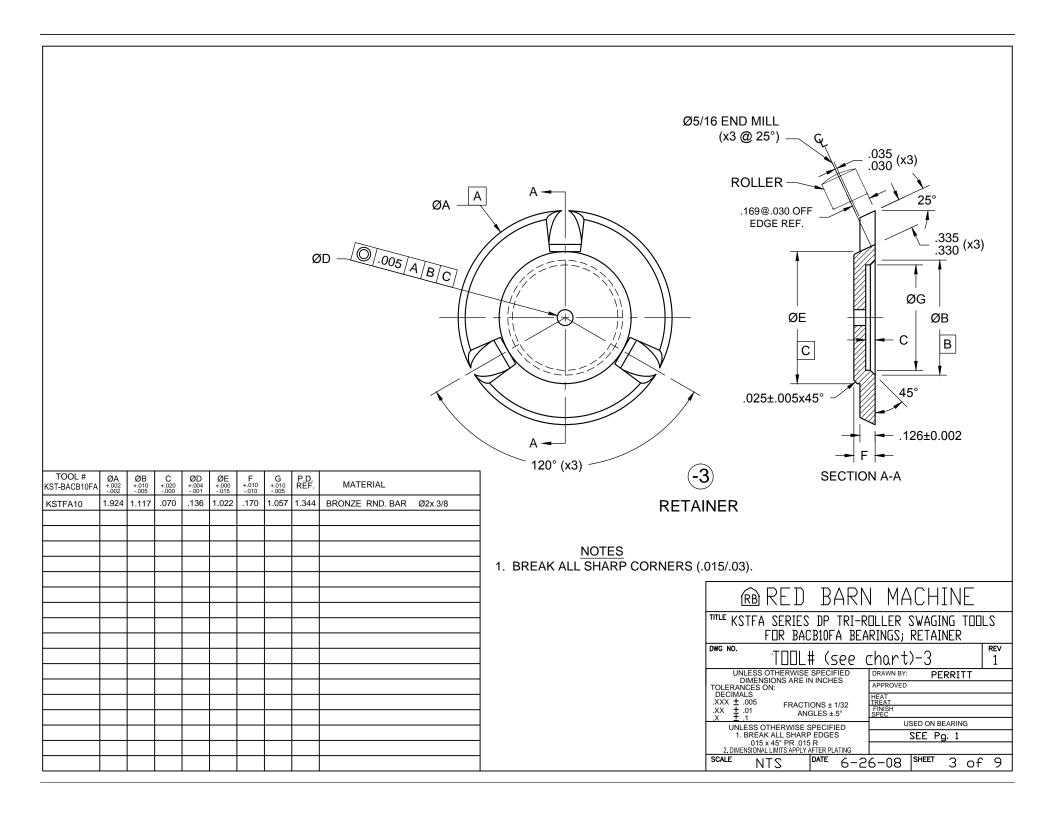
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; ROLLER REV

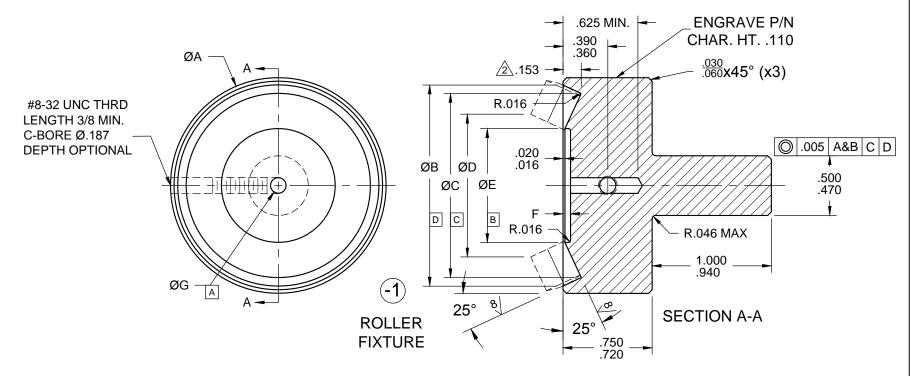
DWG NO. TDDL# (see chart)-5 UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005 FRACTIONS ± 1/32
.XX + .01 ANGLES ± .5°
.X ± .1 DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON BEARING SEE Pg. 1

UNLESS OTHERWISE SPECIFIED

1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

DATE 6-26-08 SHEET 4 of 9 NTS





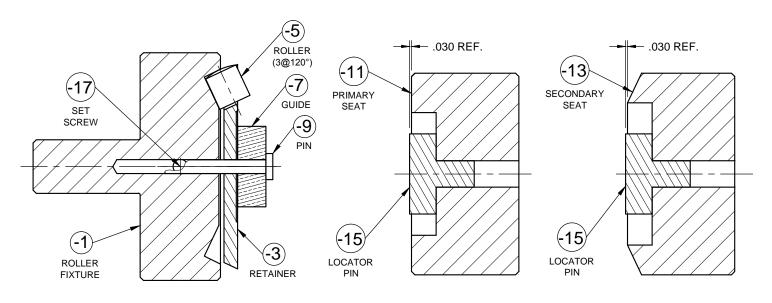
TOOL # KST-BACB10FA	ØA +.000 030	ØB +.008 000	ØC +.008 000	ØD P.D. REF.	ØE +.008 000	F +.030 000	ØG +.000 001	MATERIAL		
KSTFA10	2.100	1.837	1.690	1.344		.040	.131	0-1	DRILL ROD	Ø2-1/8 x 1-7/8
									·	

NOTES

- 1. BREAK ALL SHARP CORNERS (.015/.03).
- DIMENSION TO BOTTOM OF R.016=.153; DIMENSION TO SHARP CORNER=.158.
- 3. -1 BEARING RACE SUFACES MUST HAVE SMOOTH APPEARANCE, FREE FROM MACHINING MARKS AND GROOVES. ____
- 4. <u>DO FIRST ARTICLE INSPECTION</u> BEFORE HEAT TREATING.

@RED BARN MACHINE							
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; ROLLER FIXTURE							
DWG NO. TOOL# (see chart)-1	REV 1						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: UNLESS OTHERWISE SPECIFIED DRAWN BY: PERRITT APPROVED							
DECIMALS .XXX ± .005 .XXX ± .01 .XX ± .01 ANGLES ±.5° FRACTIONS ± 1/32 FINISH FINISH SPEC BLACK □XID							
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES USED ON BEARING SEE Pg. 1							
.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING							
SCALE NTS DATE 6-26-08 SHEET 2 of	` 9						

	REVISIONS										
REV	DESCRIPTION	DATE	INITIAL	APPROVED							
1	CHANGED -5 ROLLER RADUIS FROM .005010, TO .015020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW							



DRILL PRESS TRI-ROLLER SWAGING TOOL ASSEMBLY

NOTES

- 1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- 3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

BEARINGS & TOOLS COVERED								
BEARING #	TOOL#							
BACB10FA10	KSTFA10							

- 1							TITL
AS Q	SY B/O	PART#	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.]''''
		-1	1	ROLLER FIXTURE	SEE CHART	2	DW
		-3	1	RETAINER	SEE CHART	3]""
		-5	3	ROLLER	SEE CHART	4	\vdash
		-7	1	GUIDE	SEE CHART	5	TC
		-9	1	PIN	SEE CHART	6	.X
		-11	1	PRIMARY SEAT	SEE CHART	7	.X .X
		-13	1	SECONDARY SEAT	SEE CHART	8]
		-15	2	LOCATING PIN	SEE CHART	9	_
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S	sc

® RED BARN MACHINE

TILE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS

SEE CHART ABOVE FOR TOOL NO, 11

TOLERANCES ON:

DECIMALS
.XXX ± .005 FRACTIONS ± 1/32
.XX ± .01 ANGLES ±.5°
.X ± .1

UNLESS OTHERWISE SPECIFIED

1. BREAK ALL SHARP EDGES

APPROVED

HEAT LISTED PER ITEM
FINISH LISTED PER ITEM
SPEC USED ON BEARING
SEE ABOVE

1 of 9

015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING

CALE NTS DATE 6-26-08 SHEET

		REVISIONS										
	REV	DESCRIPTION	DATE	INITIAL	APPR							
	_		-	-	_							

						1,			V)		® RED BARN MACHINE	
ASS QT	Y ASS Y QTY	Y B/C	PART#	UNIT		DESCRIPTION				MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.	TITLE ——	
			-1	1	RND			X		6061	Ø8-1/4 x 3-7/8	2	DWG NO	RE
						\mathcal{L}	$oldsymbol{\mathcal{X}}$						UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMAL PROVED DECIMAL PROVED	_
						X	\ '						DECIMALS .XXX ± .005 .XX ± .01 .X ± .01 .X + .00 OT IF DIVISION DECISION USED ON MODEL	
						<u> </u>							UNLESS OF HERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	_
Г	ASS	Y											$^{\text{SCALE}}$ NTS $^{\text{DATE}}$ 8–15–07 $^{\text{SHEET}}$ 1 c	f

REVISIONS									
REV	DESCRIPTION	DATE	APPROVED						

NOT APPROVED FOR PRODUCTION

			r# QTY		DESCRIPTION					
			-1	ı	1					
		DRAWN BY: PERRITT			— \ Г		$D \wedge D M$	$\Lambda \Lambda \Lambda \cap$	LITN	
		CHECKED HEAT_		(<u>RB</u>	1 [2	くヒリ	RAKIN	MAL	$\Box\Box\Box$	
		TREAT FINISH SPEC		TITLE						
[USED ON MODEL	UNLESS OTHERWISE SPECIFIE DIMENSIONS ARE IN INCHES	D							
	?	TOLERANCES ON: DECIMALS .XXX ± .005 EDACTIONS + 1						-		
ł		XX ± .005 FRACTIONS ± 1 .XX ± .01 ANGLES ±.6		DWG 1	NO.		PART	#		REV.
f		UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES)				1 1 11 \ 1	11		
		.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	3	SCALE		NTS	DATE 1-28-0	06 ^{sheet} :	l of	1